

holes piercing the heads of the set-screws in two directions in order to allow a pin to be used when tightening the screws. A better idea, however, is to have the screw-heads extend out through the wall and, if this is solid, to have cored or drilled holes through which the heads of the screws may pass.

In Fig. 24 is another closed drill jig in which the work is located against the finished seats and held down by the set-screws *A* in the straps *B*. All the holes, except those marked *C*, are drilled

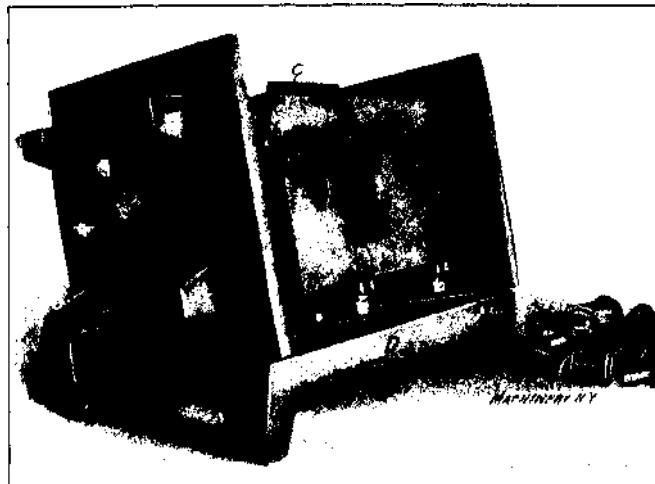


Fig. 25. Jig in Fig. 24 in Position for Drilling Holes at an Oblique Angle with Jig Base

in the usual manner, the jig standing on its own feet, but when drilling the holes *C*, which come on an angle, the special stand *D* is employed, which brings the holes in the right position for drilling, as illustrated in Fig. 25. If only the holes *C* were to be drilled, the feet on the side opposite the guiding bushings for these holes could have been planed off, so that they would have been in a plane perpendicular to the axis of the holes. This last jig has a peculiar appearance, on account of the end walls coming up square, as shown in the illustrations, but this design was adopted only to simplify matters for the patternmaker, it being easier to make the pattern this wa<sup>r</sup>.